

Work Order ID 63921

November 19, 2010 7:25:24 AM



Page 1

Item ID: D212-725-1-115

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 11/19/10 Start Qty: 2.00



Cust Item ID:

Required Date: 11/19/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *W*

Date: 10/11/22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

B

100

0.00



Small Fab

Memo

0.00

Small Fab

1-Cut as per dwg
2-Make radius as pre dwg and deburr

=> m-l 10/11/22

(2X)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/10/11/22

(x2)

120

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> 10/11/22

x2 0

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Item ID: D212-725-1-115

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Setup Start

Stop

Start Date: 11/19/10 Start Qty: 2.00

Required Date: 11/19/10 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

2 BK 10-11-22

140

Identify as per dwg & Stock Location: P.O

0.00

Packaging

Memo

0.00

Packaging

3428
RACV

10/11/22

150

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

ck 10/11/23 MF
10-11-22

Picklist Print

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Page 1

Work Order ID: 63921

Parent Item: D212-725-1-115

Parent Item Name: Angle



Start Date: 11/19/10

Required Date: 11/19/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.10.26 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A1.50X2.00X. 125		Purchased	No			100	f	12.0000	0.1	0.210526			



2024-T3 ANGLE 1.5 X 2 X .125



Location

Loc Qty

Loc Code

MAT

12

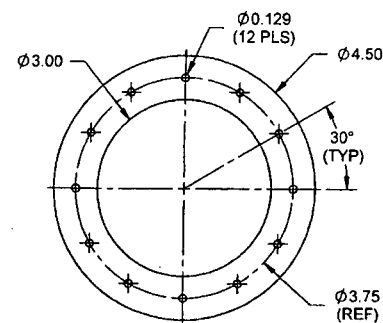
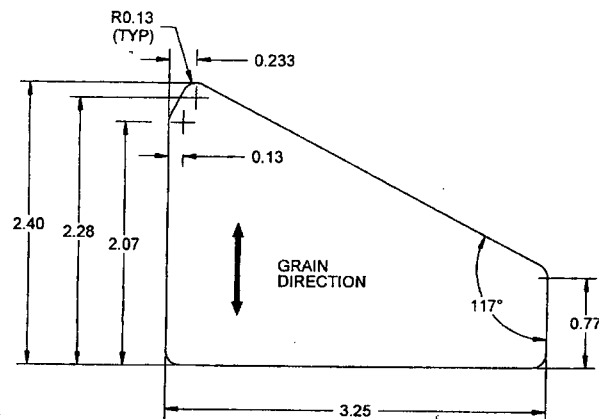
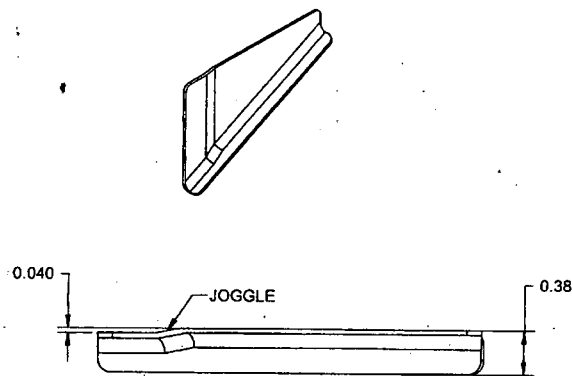
116085

12

M-L 10/11/22

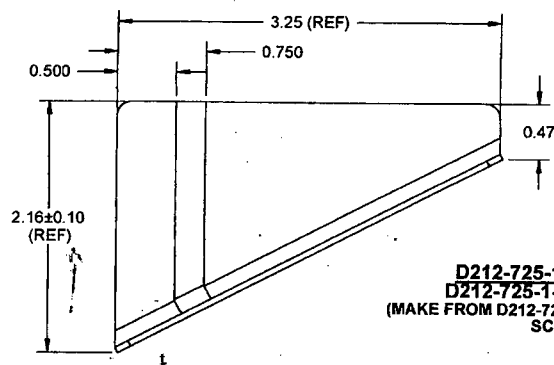
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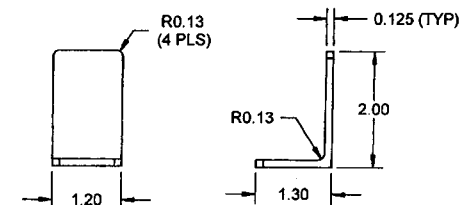


D212-725-1-103 DOUBLER

D212-725-1-113F FLAT PATTERN
SCALE 1:1



D212-725-1-113 GUSSET
D212-725-1-114 OPPOSITE
(MAKE FROM D212-725-1-113F FLAT PATTERN)
SCALE 1:1



D212-725-1-115 ANGLE

RELEASED
2009-10-09

D212-725-1-103 NOTE:

1) MATERIAL: 2024-T3 SHEET 0.050 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S0.050)

D212-725-1-113/-114 NOTE:

2) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S0.040)

D212-725-1-115 NOTE:

3) MATERIAL: 2024-T3511 (QQ-A-200/3F) ANGLE EXTRUSION (REF. DART SPEC. M2024T3-A)

GENERAL NOTES:

4) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

7) BREAK ALL SHARP EDGES 0.005 TO 0.010

8) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN AW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED <i>[Signature]</i>	DRAWING NO. D212-725-1
DATE 07.05.11	TITLE 212S DETAIL PARTS	REV. B SHEET 36 OF 44 SCALE 1:2
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